DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/Ala Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-012255
Date Inspected: 01-Feb-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	See below	**CWI Present:**	☑ Yes ☐ No
Inspected CWI report:	☐ Yes ☑ No ☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Electrode to specification:	☑ Yes ☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes ☐ No ☐ N/A	**Verified Joint Fit-up:**	☐ Yes ☑ No ☐ N/A
Approved Drawings:	☑ Yes ☐ No ☐ N/A	**Approved WPS:**	☑ Yes ☐ No ☐ N/A
		Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A

Bridge No: 34-0006
Component: Tower Components

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10
This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint SSTL4-1G/L-28 located inside PCMK south tower, lift 4, skin E to corner closure plate at bottom of 127M double diaphragm. Welder was identified as 040533. ZPMC QC was identified as CWI Liu Zhong An (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Nan and Xiao Jun Peng.

FCAW welding of weld joint SSTL4-1H/L-98 located inside PCMK south tower, lift 4, skin A to corner closure plate at top of 131M double diaphragm. Welder was identified as 053869. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4332-TC-P4-F-1. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Nan and Xiao Jun Peng.

FCAW welding of weld joint SSTL4-1H/L-31 located inside PCMK south tower, lift 4, skin E to corner closure plate at bottom of 131M double diaphragm. Welder was identified as 053869. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P4-F. Also present at this

location and appearing to be monitoring the welding related operations were ABF Representatives Li Nan and Xiao Jun Peng.

SMAW repair welding of weld joints SSTL4-1G/L-128, 129, 144 located inside PCMK south tower, lift 4, skin E at top of 127M double diaphragm. Welder was identified as 040581. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345+485-SMAW-4G(4F)-repair, WPS-345-SMAW-4G(4F)-repair, WPS-345+485-SMAW-3G(3F)-repair, respectively. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Li Nan and Xiao Jun Peng.

Bay 11

No welding was observed being performed in Bay 11.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
No significant conversations.

Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer